

Date: Wednesday, 15/10/2008 2:34:52 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GAS SPRING		
Job Number	: 42606		Part Number	: D355211		
Estimate Number	: 12941		Drawing Number	: D3552 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/10/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 22/10/2008	Qty:	20
Previous Run	: 38105		Um:	Each		
Written By	:		Comment	: Est Rev:A New Issue 06-11-13 EC		
Checked & Approved By	:					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: Issue P/O: <u>7379</u> <u>C208110114</u> Purchase Part Number: B8-240-575-150N Supplier: LS Technologies Certificate of conformity is required <u>(20)</u>
2.0	B8 240 575 150N	 Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) CARBON STEEL GAS SPRING
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Receive & Inspect For Transit Damage Ensure certificate of conformity is attached <u>P. J. Johnson (20)</u>
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK <u>S. 08/10/2011 (X20) locates</u> Test for correct pressure
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Identify and Stock: <u>118/4/22 (60)</u> Location:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 42606

Part Number: D355211

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/22 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/10.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

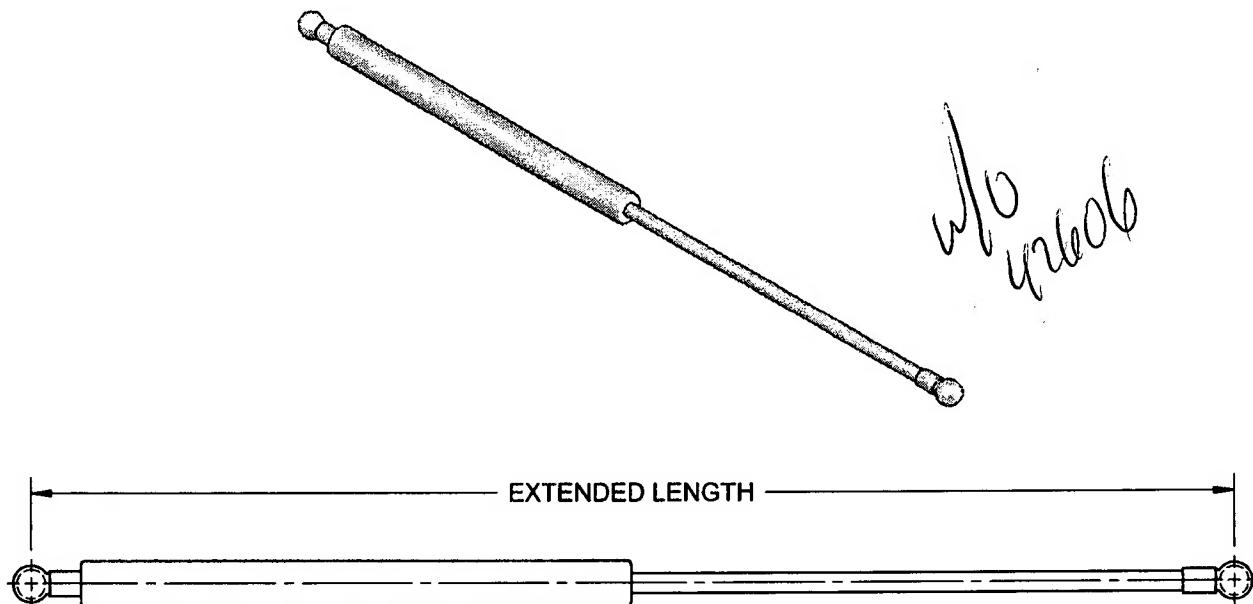
NOTE: Date & initial all entries

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>BS</i>	APPROVED <i>TM</i>	DRAWING NO. <b>D3552</b>	REV. C	SHEET 1 OF 1
DATE <b>07.06.01</b>		TITLE <b>GAS SPRING</b>	SCALE	NTS
REV	DATE	DESCRIPTION		
A	06.09.15	NEW ISSUE		
B	06.10.24	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5		
C	07.06.01	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7		

**RELEASED**  
07.07.11  
Per Rev A1001

## SPECIFICATION CONTROL DRAWING



**D3552-X GAS SPRING**

DART P/N	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	C8-220-530-070N
D3552-3	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	C8-175-430-150N
D3552-7	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	B8-220-530-070N
D3552-9	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N
D3552-11	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	B8-240-575-150N

**NOTE:**

1) IDENTIFY WITH DART P/N "D3552-X" USING WHITE FINE POINT PERMANENT INK MARKER

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## Certificate of Compliance

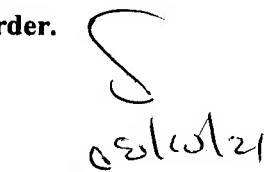
This is to certify that the parts listed below meets specifications as required by your order.

**20 Units: B8-240-575-150N Gas Spring**

**Country of Manufacture: Canada**  
**Date of Manufacture : October 2008**  
**This product is ROHS compliant.**

**We certify no mercury was used in the manufacture of this order.**

Purchase Order # 00007379  
Invoice # 4506

A handwritten signature in black ink, appearing to read "Nolan Fehr".

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr".

Nolan Fehr  
Manager